

Work Order ID 131534

Tuesday, April 14, 2015 7:48:48 AM

131534

Page 1

Item ID: D3651-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Base Assembly

Start Date: 4/14/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/14/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MW*Date: *15-04-14* Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
Number

Insp.

Stamp
APR 15 2015

Draw Nbr

Revision Nbr

D3651

Rev B

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

110

Small Fab

0.00

110

Small Fab

Memo

0.00

Small Fab

1-Assemble as per dwg D36512- Seal all mating surfaces and gaps using
Proseal 700 fire wall sealant as per dwg D3651 Batch: *M132021* 3-install
D3651-1 using 3M high performance contact adhesive 1357 as per dwg
D3651 Batch: ~~*M132021*~~
M 127394

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

DAS
30
9-89

APR 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Run Start ***NR1***

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Date:

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Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: CR

0.00

130

Packaging

Memo

0.00

DAS
30
9-89

)

APR 15 2015

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 1504-16

MP
15-4-16

DQA: _____ Date: _____



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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Picklist Print

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Work Order ID: 131534

131534

Parent Item: D3651-041

D3651-041

Parent Item Name: Aft Base Assembly

Start Date: 4/14/2015

Required Date: 4/14/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

CR3523-4-02

Purchased

No

100

Each

593.0000

58

58

CR3523-4-02

RIVET

**

FF

APR 16 2015

Location

Loc Qty

Loc Code

GA

126

m130415

126

ST318

467

m130415

67

m131340

200

m131803

200

28

30

D3651-043

Manufactured

No

110

Each

5.0000

1

1

D3651-043

Flange Weldment

**

FF

Location

Loc Qty

Loc Code

ST227

5

126823

5

1

D3651-1

Manufactured

No

110

Each

7.0000

1

1

D3651-1

Gasket

**

FF

Location

Loc Qty

Loc Code

ST227

7

126523

5

95811

2

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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D3651-041

Parent Item Name: Aft Base Assembly

Start Date: 4/14/2015

Required Date: 4/14/2015

Start Qty: 1.00

Required Qty: 1.00

D3651-11

Manufactured No

110

Each

4.0000

1

1

D3651-11

Gasket

**

FF

APR 16 2015

Location

Loc Qty

Loc Code

ST227

4

128231

4

1

D3651-13

Manufactured No

110

Each

6.0000

1

1

D3651-13

Outside Doubler

**

FF

Location

Loc Qty

Loc Code

GA

2

94690

1

95404

1

ST227A

4

128232

4

1

D3651-9

Manufactured No

110

Each

5.0000

1

1

D3651-9

Inside Doubler

**

FF

Location

Loc Qty

Loc Code

ST227A

5

127454

1

128233

4

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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